

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029179**Date Inspected:** 25-Feb-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** USA Hoist**Location:** USA Hoist, Crest Hill, IL

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|------------------------------------|--------------|----|-----|
| CWI Name: | Robert Zimny | | |
| Inspected CWI report: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A |

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| CWI Present: | Yes | No |
| Rod Oven in Use: | Yes | No N/A |
| Weld Procedures Followed: | Yes | No N/A |
| Verified Joint Fit-up: | Yes | No N/A |
| Approved WPS: | Yes | No N/A |
| Delayed / Cancelled: | Yes | No N/A |

Bridge No: 34-0006**Component:** SAS Tower Elevator**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Fritz Belford was at the USA Hoist shop in Crest Hill, Illinois between the times noted above in order to monitor Quality Control functions and the in process work being performed by USA Hoist personnel. The following items were observed:

Manolo Luna (B):

Welder Luna was observed finishing welding the gussets (Part Number 916001-02) to the formed channels (Part Number 916004 of dwg #916000) and then moved on to welding the back plates to the formed vertical channels (Part Number 916031) x 4 of the cab frame using 1.1mm E71T-1C Famiarc DW-50 wire electrode. The shielding gas being used was noted a combination of 75% Argon and 25% CO2 with flow rate of 38 CFH. The welding parameters measured were 26 volts and 190 amperes and were in compliance with the Welding Procedure Specification (WPS) FCAW3210.

Matt Wasigi (A):

Welder Wasigi was observed continuing with welding three (3) hinges each to the number 1 door stop assembly and the number 2 door assembly using 1.1mm E71T-1C Famiarc DW-50 wire electrode. The shielding gas being used was noted a combination of 75% Argon and 25% CO2 with flow rate of 37 CFH. The welding parameters measured were 26 volts and 195 amperes and were in compliance with the Welding Procedure Specification (WPS) FCAW3210. After welding Mr Wasigi was observed assisting Mr Ulloa in fitting the number 2 & 3 door assemblies to their respective door stop assemblies checking for fit and clearances.

Genaro Ulloa (D):

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Welder Ulloa was observed fitting the number 2 door to the number 2 door stop assembly and the number 3 door to the number 3 door stop assembly. Mr Ulloa was noted checking the fit of the doors ensuring proper fit and clearances before tack welding the hinges to the number 3 door assembly and installing door locks on both door assemblies. The welder was noted using gas shielded FCAW-G with 1.1mm E71T-1C Familiarc DW-50 wire electrode implementing USA Hoist Welding Procedure Specification FCAW3210. The shielding gas being used was noted a combination of 75% Argon and 25% CO2 with flow rate of 35 CFH. The welding parameters measured were 26 volts and 196 amperes and were in compliance with the Welding Procedure Specification (WPS) FCAW3210.

The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Conversations this day as required for scope of work.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials

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for your project.

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| Inspected By: | Belford,Fritz | Quality Assurance Inspector |
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| Reviewed By: | Foerder,Mike | QA Reviewer |
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